



Dart Aerospace Ltd.
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D205-633-024
Job Sheet 193051



Part No: D205-633-024

Job Qty: 1 pcs

Part Name: Heli-Access-Step™ RH - 31" Extended Height Gear, Simplex Tank Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/8/19

Job Tracking No:

Due Date: 4/30/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *order 15019*

Note: DWG REV C SHEET 17 IPP Rev:A new issue Rev B dwg 07-11-19 DD verified by:EC lpp RevB 11.07.26 per NCR 11-628 EC verified by:JLM IPP Rev:C 11.09.12 remove D3165-1 DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs	4/30/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		



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Container No: S176544



Part: D205-633-024

Job No: 193051

Serial No/Batch: S176544

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH96-57 Issue 5 FAA-STD SR005921

					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
120	QC 4	1 pcs	4/30/19	0.00 0.00	QC 4 - 28	68-6
					QC 4 - 58	69
					QC 4 - 69	SVQ
					QC 4 - 9	68-6
					QC 4 - 46	69
130	Packaging 3-1 - Stock - B4B	1 pcs	4/30/19	0.00 0.00	Packaging 3 - 1 - B4B	SVQ
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
135	DC - 1 - B4B	1 pcs	4/30/19	0.00 0.00	DC - 1 - B4B	DAG
					DC - 2 - B4B	21 APR 30 2019
140	QC 21 - FG	1 pcs	4/30/19	0.00 0.00	QC 21 - FG - 21	9-35
					QC 21 - FG - 70	DAG
					QC 21 - SA - 53	21 APR 30 2019
Part Op 110 - (Pick Kit)						
Descriptions: 120 - (QC4- 100% Inspect kits for completeness)						
130 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D205-633-024						
135 - (Document Control) Photocopy bluefile & type labels per PPP D205-633-024 CHG001						
140 - (QC21- Final Inspection - Work Order Release)						

009179

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-12A	Bolt	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5109960
AN4-14A	Bolt	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5114891
AN4-5A	Bolt	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5155698
AN4-6A	Bolt	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	5113806
AN4-7A	Bolt	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5107746
AN44-7A	Eyebolt	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5067889
AN5-14A	Bolt	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5056344
D2022-101	Spacer	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5163199
D2022-103	Spacer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5126068
D2562-013	Strut 26.63"	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5104714
D2565-201	Strut	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5104616
D2565-203	Strut	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5102556
D2565-205	Strut	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5102580
D2565-207	Strut	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5102590
D2565-209	Strut	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5102653
D2565-211	Strut	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5171971
D3437-043	Aft Strut Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5173831
D3438-042	Weldment Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5175019
MS21042L4	Nut	7 Ea (7 ea)	110-Packaging 1 - Pick Kit	5161468
MS21042L5	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5142145
NAS1149D0463J	Washer	14 Ea (14 ea)	110-Packaging 1 - Pick Kit	5157445
NAS1149D0563J	Washer	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	5156686

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN4-12A	1	130	0
	AN4-14A	1	670	0
	AN4-5A	1	179	0
	AN4-6A	3	1,001	0
	AN4-7A	1	110	0
	AN44-7A	1	4	0
	AN5-14A	1	12	0
	D2022-101	4	93	0
	D2022-103	2	23	0
	D2562-013	1	5	0
	D2565-201	1	10	0
	D2565-203	1	9	0
	D2565-205	1	3	0
	D2565-207	1	3	0
	D2565-209	1	2	0
	D2565-211	1	0	0
	D3437-043	1	0	0
	D3438-042	1	0	0
	MS21042L4	7	4,190	0
	MS21042L5	2	903	0
	NAS1149D0463J	14	5,211	0
	NAS1149D0563J	3	1,980	0

Part Specifications

Specifications could not be found.

Plex 4/8/19 8:16 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

**5.2 D205-633-021/-022/-023/-024/-025/-026 Heli-Access Step
(Simplex Model 304 Fire Attack Tank Compatible)**

QTY -021	QTY -022	QTY -023	QTY -024	QTY -025	QTY -026	Part Number	Description
X						D205-633-021	Heli-Access-Step™ (LH), High Gear
	X					D205-633-022	Heli-Access-Step™ (RH), High Gear
		X				D205-633-023	Heli-Access-Step™ (LH), Extended High Gear (31")
			X			D205-633-024	Heli-Access-Step™ (RH), Extended High Gear (31")
				X		D205-633-025	Heli-Access-Step™ (LH), Extended High Gear (39")
					X	D205-633-026	Heli-Access-Step™ (RH), Extended High Gear (39")
4	4	4	4	4	4	D2022-101	SPACER
2	2	2	2	2	2	D2022-103	SPACER
				1	1	D2562-005	STRUT
1	1					D2562-011	STRUT
		1	1			D2562-013	STRUT
1		1		1		D2563	WELDMENT ASSEMBLY
1	1					D2565-101	STRUT
1	1					D2565-103	STRUT
1	1					D2565-105	STRUT
1	1					D2565-107	STRUT
1	1					D2565-109	STRUT
*1	*1					D2565-111	STRUT
		1	1			D2565-201	STRUT
		1	1			D2565-203	STRUT
		1	1			D2565-205	STRUT
		1	1			D2565-207	STRUT
		1	1			D2565-209	STRUT
		*1	*1			D2565-211	STRUT
				1	1	D2565-301	STRUT
				1	1	D2565-303	STRUT
				1	1	D2565-305	STRUT
				1	1	D2565-307	STRUT
				1	1	D2565-309	STRUT
				*1	*1	D3165-1	SUPPORT ARM
1	1					D3437-041	AFT STRUT ASSEMBLY
		1	1			D3437-043	AFT STRUT ASSEMBLY
				1	1	D3437-045	AFT STRUT ASSEMBLY
	1		1		1	D3438-042	WELDMENT ASSEMBLY
1	1	1	1	1	1	AN4-5A	BOLT
4	4	3	3	3	3	AN4-6A	BOLT
1	1	1	1	1	1	AN4-7A	BOLT
1	1					AN4-11A	BOLT
		1	1	1	1	AN4-12A	BOLT
1	1	1	1	1	1	AN4-14A	BOLT
1	1	1	1	1	1	AN44-7A	EYEBOLT
1	1	1	1	1	1	AN5-14A	BOLT
16	16	14	14	14	14	AN960JD416	WASHER
3	3	3	3	3	3	AN960JD516	WASHER
8	8	7	7	7	7	MS21042L4	NUT (or MS21042-4)
2	2	2	2	2	2	MS21042L5	NUT (or MS21042-5)

* ONLY INSTALLED IF TANK IS REMOVED

Change Record

PAGE 1 OF 1

Part Number: D205-633-023/-024

Description: HELI-ACCESS STEP, EXTENDED HIGH GEAR LH/RH (31")

[illegible]